

5/50

DART AEROSPACE LTD	Work Order:	24566
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A^	Qty:	162

Page 1 of 1

RF 02/10/17

Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JF	05.10.13	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: M16454	EN	05/11/13	160
3	MV	Machine per folio FA183 and Dwg D3067	EN	05/11/13	160
4	QC2	Inspect parts as they come off the CNC machine	EN	05/11/13	160
5	QC7	Second inspection	TRW	05/11/13	160
6	MV	Deburr	/	/	/
7	GB	Bend as per Dwg D3067	SD	05/11/15	162
8	QC5	Inspect work to Step 7	/	05/11/15	162
9	WA	Identify and stock	/	05/11/15	162
10	AC	Cost / Part	SAC	05-11-21	162
11	DC	Close W/O Inspect level 21	(1)	05-11-21	162

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	jl
C1	03.01.21	Remove step 6 (Deburr)	RF	jl

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-13	3	16 (2 stacks) mached while maching	18 ABP/et2	Scrap, destroy and Replace.	EN 05-11-17	J 05-11-15	18 ABP/et2	J 05-11-15

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/11/201

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	24566
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>EP</i>	Audited by:	<i>MK</i>	Prototype Approval:	<i>N/A</i>
Date:	05/11/13	Date:	05/11/13	Date:	03.10.07

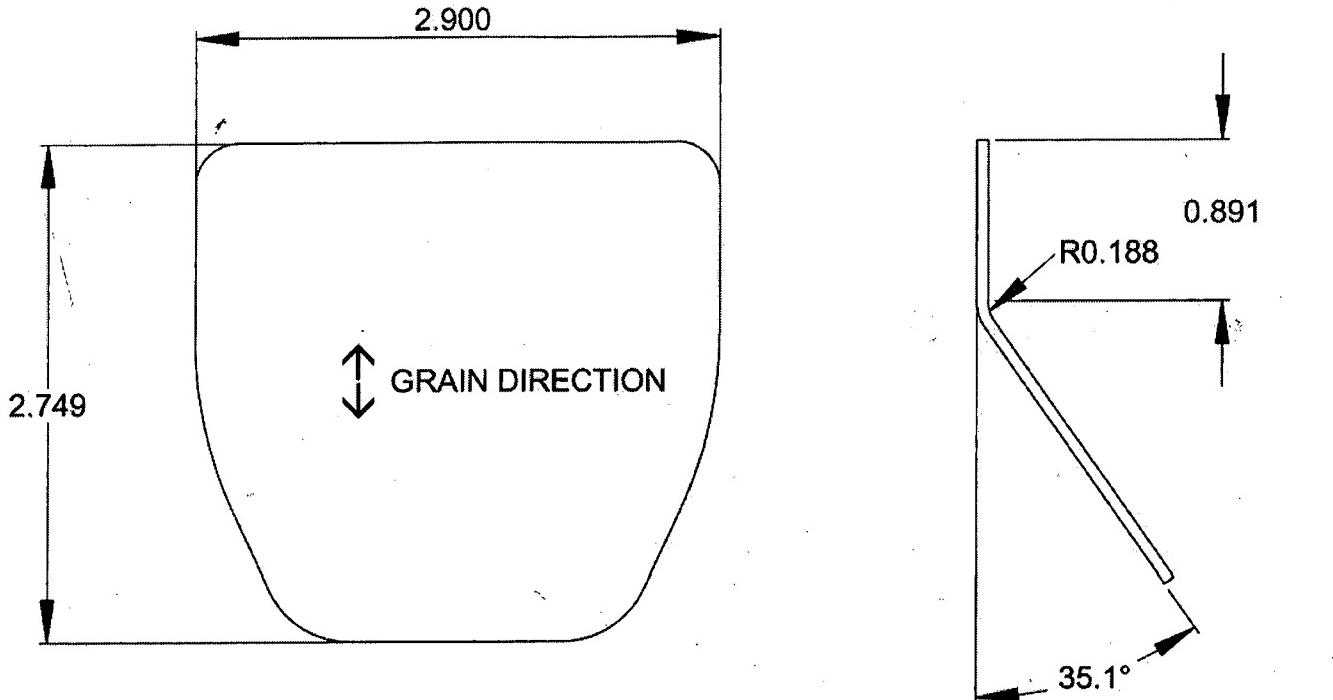
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	[Signature]

RELEASED
03.10.07



DESIGN <i>CR</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN

D3067-1 BEND DETAIL

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO
WITHOUT

WORK C

NO. 24566

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 13, 2005
11:58 am

Work Order No	:	0024566	Department Code:	
Project Name	:	D3067-1	Burden Flags	: NNNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3067-1	Invoice Number	:
Description	:	End Plate	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	160	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	10-13-05	Est Mark Up	: 0.000%
Est Finish Date	:	12-15-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

Date: Thursday, 11/17/2005 11:51:39 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END PLATE		
Job Number	: 24566			Part Number	: D30671	
Estimate Number	: 10547			Drawing Number	: D3067 REV A	
P.O. Number	:			Project Number	:	
This Issue	: 11/17/2005	S.O. No.	:	Drawing Revision	: A	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 11/24/2005	Qty: 162 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est:03.01.21 Remove step 6 (Deburr) KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA183 and Dwg D3067		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg D3067		
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO NEXT STEP		

Date: Thursday, 11/17/2005 11:51:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 24566

Part Number: D30671

Job Number:



Seq. #: Machine Or Operation:

Description :

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

